



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW1205G00231-3G-PO

Job Sheet 197304



5 PL

Part No: RBW1205G00231-3G-PO

Job Qty: 3 pcs

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Created By: Patrick Lussier

Due Date: 9/2/19

Description:

Type: Stock

Note: DWG RBW1205G00231-3G Rev.2B IPP Rev. A 18.10.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs 5 pcs AC	9/2/19		0.00	0.00	Purchasing - 1		AC SEP 04 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Recelve - B4B	3 pcs 5 pcs AC	9/2/19		0.00	0.00	Packaging 2 - 1 - B4B		AC SEP 04 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



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1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S211390



Part: RBW1205G00231-3G

Job No: 197304

Serial No/Batch: S211390

Revision: 28

Inspector:

Exp Date:

Instructions:

Date: 09/04/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	3 pcs	9/2/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
130 Packaging 3-1 - Stock - B4B	3 pcs	9/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	3 pcs	9/2/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - Purchasing - Issue P/O: **HB 049522** MANUFACTURE RBW1205G00231-3G AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required
 110 - Receive & Inspect for Damage & Mat'l Certs
 120 - QC6- All purchased or subcontracted products
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

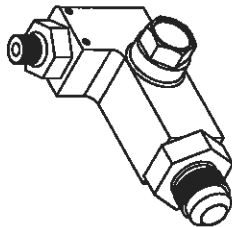
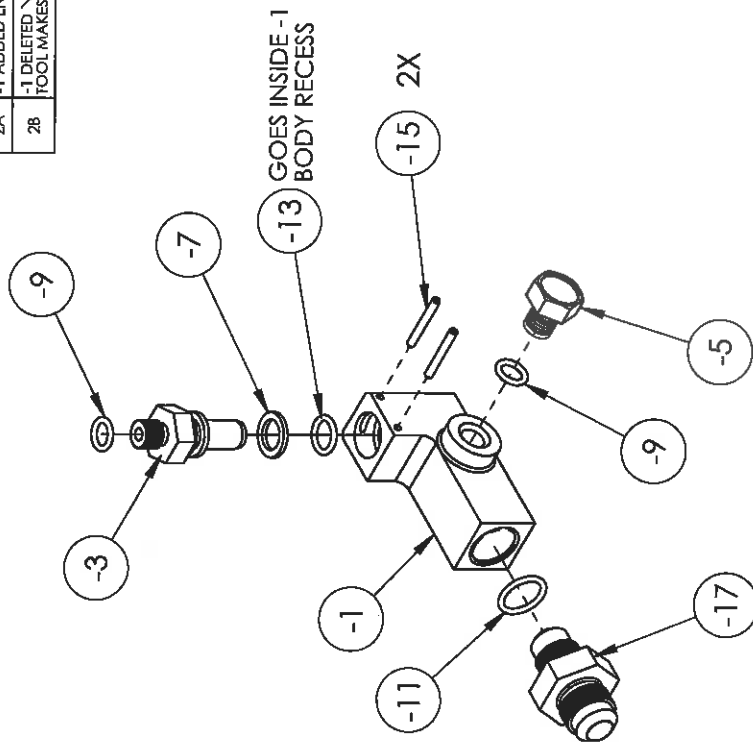
x3 Hws July 04. 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBW1205G00231-3Gp	Main Rotor Damper Oil Filling Adapter	3 pcs (1 ea)	100-Purchasing	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW1205G00231-3Gp	3	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 I ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\checkmark \phi .37 \times 90^\circ$ NEAR SIDE CALLOUT FROM 5/16-24 ∇ .50 BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REFERENCE ONLY

FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131. USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER					 RED BARN MACHINE	
ASSY QTY	B/O	Part #	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
		-3	TUBE	6061	Ø3/4 X 1-1/2	3
		-5	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #ANB14-2D (MODIFIED)	4
		-7	WASHER	NYLON	Ø1/2 X 3/16	4
	B/O	-9	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	5
	B/O	-11	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
	B/O	-13	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
	B/O	-15	ROLL PIN	STEEL	Ø2mm X 18mm MCMASTER-CARR #91611A108	1
	B/O	-17	FITTING	ALUMINUM	MS24392D6	1

TITLE		RED BARN MACHINE	
MAIN ROTOR DAMPER OIL ADAPTER			
DWG NO.	RBW1205G00231-3G	REV	2B
MAT'L		DRAWN BY:	PERRITT
UNLESS OTHERWISE SPECIFIED		APPROVED	<i>D Well</i>
DIMENSIONS ARE IN INCHES		HEAT TREAT	
FRACTIONS ± 1/32		FINISH	
ANGLES ± .5°		SPEC	
1. ALL SHARP EDGES .015 x 45°		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA	
SCALE	1:2	DATE	2/23/2011
		SHEET 1 OF 5	

RED BARN MACHINE

ICE MAIN ROTOR DAMPER OIL ADAPTER

WG NO.	RBW1205G00231-3G	REV	20
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DATE	11/11/11	TIME	11:11
DRAWN BY: PERRITT		DATE	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

APPROVED D Weil
HEAT

	FRACTIONS ± 1/32	TREAT FINISH
.003		
.XX		
.X		
.01		
X		
Y		
± .1		
± .5°		

BREAK ALL SHARP EDGES .015 X 45°
OR .015R

CRACK	DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
AGUSTA		

SCALE	1:2	DATE	2/23/2011	SHEET 1 OF 5
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER POHB043922



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043922

PO Date: 7/4/19

Due Date: 9/2/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Revision

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	197299	RBW6205G03731-3GP	✓		Trim Tab Bending Gauge Assembly REV 4	Firmed	-	9/2/19	4 Ea	✓ 0 Ea	4 Ea	\$1,204.00/Ea	\$4,816.00
									4X SEP 04 2019		AC		
2	197304	RBW1205G00231-3Gp	✓		Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	9/2/19	5 pcs	✓ 0 pcs	5 pcs	\$725.00/pcs	\$3,625.00
									5X SEP 04 2019		AC		
												DAS 61 9-89	
3	197307	RBW6005G01431-3Gp	✓		Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	9/2/19	2 pcs	✓ 0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
									2X SEP 04 2019		AC		
Grand Total:												\$10,541.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

[Signature]

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POHB043922



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2	197304	RBW1205G00231-3Gp			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	9/2/19	5 pcs	0 pcs	5 pcs	\$725.00/pcs	\$3,625.00
3	197307	RBW6005G01431-3Gp			Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	9/2/19	2 pcs	0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
Grand Total:												\$10,541.00	

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[Signature]



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POHB043922



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Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

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1	197299	RBW6205G03731-3GP			Trim Tab Bending Gauge Assembly REV 4	Firmed	-	9/2/19	3 Ea	0 Ea	3 Ea	\$1,204.00/Ea	\$3,612.00
2	197304	RBW1205G00231-3Gp			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	9/2/19	3 pcs	0 pcs	3 pcs	\$725.00/pcs	\$2,175.00
3	197307	RBW6005G01431-3Gp			Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	9/2/19	2 pcs	0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
Grand Total:												\$7,887.00	

Order Notes

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A049 SUPPLIER AWARENESS

Plex 7/4/19 11:20 AM dart.lussier.patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 677

Date: 8/30/2019
PO Ref: HB043922 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

DAS
61
9-89

Qty	Item	Part No.
4 ✓	TRIM TAB BENDING GUAGE ASSEMBLY	RBW6205G03731-3G REV - 4 ✓
5 ✓	MAIN ROTOR DAMPER OIL FILLING ADAPTER	RBW1205G00231-3G REV - 2B ✓
2 ✓	DIAL INDICATOR MAIN ROTOR DAMPER SUPPORT	RBW6005G01431-3G REV - 1A ✓

F 8128 4801
7428

RECEIVED

SEP 04 2019

DART AEROSPACE LTD.

Received by: _____
Packaged by: ADP
Checked by: W

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043922 ✓ Dated: 8/30/2019

Our Order / Job No: AWT-HB043922 A2 Order Qty: 5 ✓

Part Name: MAIN ROTOR DAMPER OIL FILLING ADAPTER

Part Number RBW1205G00231-3G ✓

Lot Size: N/A Ship Date: 8/30/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW1205G00231-3G Rev: 2B

61
9-89

Material Size and Type: -1, -3/6061 ALUM.; -7/NYLON

Material Specifications: ALUMINUM: ASTM B221; NYLON: ASTM D5989-5

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 8/30/2019

Signed: Hemant M. Patel

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com